



Designation: F 439 – 99a

Standard Specification for Chlorinated Poly (Vinyl Chloride) (CPVC) Plastic Pipe Fittings, Schedule 80¹

This standard is issued under the fixed designation F 439; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This specification covers chlorinated poly(vinyl chloride) (CPVC) Schedule 80 pipe fittings. Included are requirements for materials, workmanship, dimensions, and burst pressure.

NOTE 1—The threaded CPVC fittings covered by this specification were covered previously in Specification F 437.

1.2 The text of this specification references notes, footnotes, and appendixes which provide explanatory material. These notes and footnotes (excluding those in tables and figures) shall not be considered as requirements of this specification.

1.3 The values stated in inch-pound units are to be regarded as the standard. The values in parentheses are given for information only.

1.4 The following safety hazards caveat pertains only to the test method portion, Section 8, of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

- D 618 Practice for Conditioning Plastics and Electrical Insulating Materials for Testing²
- D 1599 Test Method for Short-Time Hydraulic Failure Pressure of Plastic Pipe, Tubing, and Fittings³
- D 1600 Terminology for Abbreviated Terms Relating to Plastics²
- D 1784 Specification for Rigid Poly(Vinyl Chloride) (PVC) Compounds and Chlorinated Poly(Vinyl Chloride) (CPVC) Compounds²
- D 2122 Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings³
- D 2749 Symbols for Dimensions of Plastic Pipe Fittings³

¹ This specification is under the jurisdiction of ASTM Committee F-17 on Plastic Piping Systems and is the direct responsibility of Subcommittee F17.10 on Fittings. Current edition approved December 10, 1999. Published April 2000. Originally published as part of D 2467 – 74. Last previous edition F 439 – 97.

² Annual Book of ASTM Standards, Vol 08.01.

³ Annual Book of ASTM Standards, Vol 08.04.

F 412 Terminology Relating to Plastic Piping Systems³

F 437 Specification for Threaded Chlorinated Poly (Vinyl Chloride) (CPVC) Plastic Pipe Fittings, Schedule 80³

F 1498 Specification for Taper Pipe Threads 60° for Thermoplastic Pipe and Fittings³

2.2 Federal Standard:

Fed. Std. No. 123 Marking for Shipment (Civil Agencies)⁴

2.3 Military Standard:

MIL-STD-129 Marking for Shipment and Storage⁴

2.4 NSF Standard:

Standard No. 14 for Plastic Piping Components and Related Materials⁵

Standard No. 61 for Drinking Water System Components—Health Effects⁵

3. Terminology

3.1 *Definitions*—Definitions are in accordance with Terminology F 412 and abbreviations are in accordance with Terminology D 1600, unless otherwise indicated. The abbreviation for chlorinated poly(vinyl chloride) is CPVC.

4. Classification

4.1 *General*—This specification covers Schedule 80 CPVC pipe fittings, intended for use with Iron Pipe Size (IPS) outside-diameter plastic pipe.

4.1.1 Fittings covered by this specification are normally molded. In-line fittings, such as couplings, unions, bushings, caps, nipples, and so forth, shall be molded or machined from extruded stock.

4.1.2 Fittings fabricated by back welding or butt fusion are not included in this specification.

5. Materials and Manufacture

5.1 This specification covers CPVC pipe fittings made from compounds meeting the requirements of Class 23447 and Class 23448 as defined in Specification D 1784.

NOTE 2—Mechanical strength, heat resistance, flammability, and chemical resistance requirements are covered in Specification D 1784.

⁴ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

⁵ Available from NSF International, P.O. Box 130140, Ann Arbor, MI 48113-0140.

5.2 *Rework Material*—The manufacturers shall use only their own clean rework fitting material, and the fittings produced shall meet all the requirements of this specification.

6. Requirements

6.1 Dimensions and Tolerances:

6.1.1 Fitting sockets, inside diameters (waterways), minimum wall thicknesses, and dimensions shall be as shown in Tables 1-5 when measured in accordance with Test Method D 2122.

6.1.2 When multistep reducer bushings are cored out, the inner socket shall be reinforced from the outer wall by a minimum of three ribs extending from the top of the inner socket to the deepest extremity of the coring. The transition from D to DJ (Table 3) shall be straight, tapered as shown, or radiused. A positive taper in the same direction of the taper in the socket on the outside diameter of the bushing is optional.

6.1.3 The maximum angular variation of any opening shall be not more than $\frac{1}{2}^\circ$ off the true centerline axis.

6.1.4 The minimum wall thickness of fittings shall be 125 % of the minimum wall thickness of the corresponding size of Schedule 80 pipe for which they are designed to be used, except that for the socket, the wall thickness shall be at least equal to the minimum wall thickness of the corresponding size of Schedule 80 pipe.

6.1.5 The minimum inside diameter of the fittings shall be not less than the minimum specified inside diameter of the corresponding size of Schedule 80 pipe. This is calculated as follows:

$$(\text{minimum OD}) - 2 \times (\text{maximum wall}) = \text{minimum ID} \quad (1)$$

6.1.6 Minimum dimensions have zero negative tolerance. Tolerances on other dimensions are shown in Tables 1 and 3.

6.1.7 *Fitting Not Illustrated*—All fittings, whether illustrated in Tables 1-5 or not, shall maintain the dimensions conforming to 6.1 and 6.2.

6.2 *Threads*—For all fittings having taper pipe threads, threads shall conform to Specification F 1498 and be gaged in accordance with 8.4.

6.3 Burst Pressure:

6.3.1 The minimum burst strength of the fittings shall be not less than that calculated for the size and wall thickness of the pipe with which it is to be used, when calculated from the following equation:

$$S = P(D_o - t)/2t \quad (2)$$

where:

S = hoop stress, psi (MPa),

P = internal pressure, psi (MPa),

D_o = average outside diameter, in. (mm), and

t = minimum wall thickness, in. (mm).

Fittings tested in accordance with 8.5 shall withstand the minimum burst pressure shown in Table 6.

6.3.2 Pressures shown are minimum burst pressures and do not imply rated working pressures. The burst pressure shall be used only as an indication of quality.

7. Workmanship, Finish and Appearance

7.1 The fittings shall be homogeneous throughout and free of cracks, holes, foreign inclusions, or other defects. The

fittings shall be as uniform as commercially practicable in color, opacity, density, and other physical properties.

8. Test Methods

8.1 *Conditioning*—Condition of test specimens at $73.4 \pm 3.6^\circ\text{F}$ ($23 \pm 2^\circ\text{C}$) and $50 \pm 5\%$ relative humidity for not less than 40 h prior to test in accordance with Procedure A of Practice D 618, for those tests where conditioning is required.

8.2 *Test Conditions*—Conduct tests in the standard laboratory atmosphere of $73.4 \pm 3.6^\circ\text{F}$ ($23 \pm 2^\circ\text{C}$) and $50 \pm 5\%$ relative humidity, unless otherwise specified in the test methods or in this specification.

8.3 *Sampling*—A sufficient quantity of fittings as agreed upon between the seller and the purchaser shall be selected at random from each lot or shipment and tested to determine that the basic design is in conformance with this specification.

NOTE 3—For individual orders or specifications where supplemental tests are required, only those tests and numbers of tests specifically agreed upon between the purchaser and the seller need be conducted.

8.4 *Threads*—All taper pipe threads shall be gaged in accordance with Specification F 1498.

8.5 *Burst Pressure*—Determine the minimum burst pressure in accordance with Test Method D 1599. The time of testing each specimen shall be between 60 and 70 s.

9. Retest and Rejection

9.1 If the results of any test(s) do not meet the requirements of this specification, the test(s) shall be conducted again only by agreement between the purchaser and the seller. Under such agreement, minimum requirements shall not be lowered, changed, or modified, nor shall specification limits be changed. If upon retest, failure occurs, the quantity of product represented by the test(s) does not meet the requirements of this specification.

10. Marking

10.1 *Quality of Marking*—The markings shall be applied to the fitting in such a manner that they remain legible under normal handling and installation practices.

10.2 Content of Marking:

10.2.1 Fittings shall be marked with the following:

10.2.1.1 Manufacturer's name or trademark,

10.2.1.2 Material designation CPVC for CPVC 23447 and designation CPVC 42 for CPVC 23448,

10.2.1.3 The seal or mark of the laboratory making the evaluation for potable water contact,

10.2.1.4 Size, and

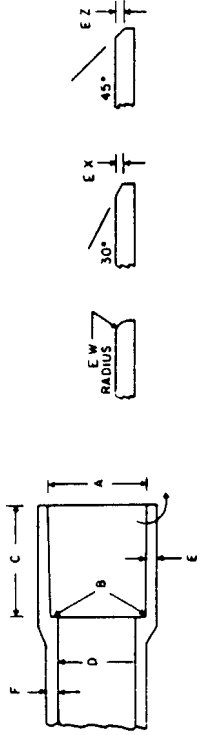
10.2.1.5 This designation "F 439," with which the fitting complies.

10.3 Where the size of the fitting does not allow complete marking, omit identification marking in the following sequence: size, material designation, F 439, and the manufacturer's name or trademark.

10.4 Markings or symbols shall be molded, hot-stamped, or applied to fittings by any other suitable method, such as printing.

10.5 Where recessed marking is used, care shall be taken to see that in no case marking causes cracks or reduces the wall thickness below the minimum specified.

TABLE 1 Tapered Sockets for CPVP Pipe Fittings, Schedule 80, in. (mm)^A



Nominal Pipe Size	A			B			C ^B		D ^C			Wall Thickness, min			Entrance, min	
	Socket Entrance Diameter			Socket Bottom Diameter			Socket Length, min	Diameter, min	E	F	EW	EX, EZ				
	Diameter	Tolerance on Nominal Diameter	Maximum Out-of-Round	Diameter	Tolerance on Nominal Diameter	Maximum Out-of-Round										
¼	0.552 (14.02)	±0.004 (0.10)	0.016 (0.41)	0.536 (13.61)	±0.004 (0.10)	0.016 (0.41)	0.625 (15.88)	0.258 (6.55)	0.119 (3.02)	0.149 (3.78)	0.02 (0.5)	0.02 (0.5)				
⅜	0.687 (17.45)	±0.004 (0.10)	0.016 (0.41)	0.671 (17.04)	±0.004 (0.10)	0.016 (0.41)	0.750 (19.05)	0.379 (9.63)	0.126 (3.20)	0.160 (4.06)	0.03 (0.8)	0.03 (0.8)				
½	0.848 (21.54)	±0.004 (0.10)	0.016 (0.41)	0.836 (21.23)	±0.004 (0.10)	0.016 (0.41)	0.875 (22.22)	0.502 (12.75)	0.147 (3.73)	0.185 (4.70)	0.03 (0.8)	0.03 (0.8)				
¾	1.058 (26.87)	±0.004 (0.10)	0.020 (0.51)	1.046 (26.57)	±0.004 (0.10)	0.020 (0.51)	1.000 (25.40)	0.698 (17.73)	0.154 (3.91)	0.195 (4.95)	0.03 (0.8)	0.03 (0.8)				
1	1.325 (33.66)	±0.005 (0.13)	0.020 (0.51)	1.310 (33.27)	±0.005 (0.13)	0.020 (0.51)	1.125 (28.58)	0.911 (23.14)	0.179 (4.55)	0.225 (5.72)	0.06 (1.5)	0.06 (1.5)				
1¼	1.670 (42.42)	±0.005 (0.13)	0.024 (0.61)	1.655 (42.04)	±0.005 (0.13)	0.024 (0.61)	1.250 (31.75)	1.227 (31.17)	0.191 (4.85)	0.240 (6.10)	0.06 (1.5)	0.06 (1.5)				
1½	1.912 (48.56)	±0.006 (0.15)	0.024 (0.61)	1.894 (48.11)	±0.006 (0.15)	0.024 (0.61)	1.375 (34.93)	1.446 (36.73)	0.200 (5.08)	0.250 (6.35)	0.06 (1.5)	0.06 (1.5)				
2	2.387 (60.63)	±0.006 (0.15)	0.024 (0.61)	2.369 (60.17)	±0.006 (0.15)	0.024 (0.61)	1.500 (38.10)	1.881 (47.78)	0.218 (5.54)	0.275 (6.99)	0.06 (1.5)	0.06 (1.5)				
2½	2.889 (73.38)	±0.007 (0.18)	0.030 (0.76)	2.868 (72.85)	±0.007 (0.18)	0.030 (0.76)	1.750 (44.45)	2.250 (57.15)	0.276 (7.01)	0.345 (8.76)	0.09 (2.3)	0.13 (3.3)				
3	3.516 (89.31)	±0.008 (0.20)	0.030 (0.76)	3.492 (88.70)	±0.008 (0.20)	0.030 (0.76)	1.875 (47.63)	2.820 (71.63)	0.300 (7.62)	0.375 (9.53)	0.09 (2.3)	0.13 (3.3)				
3½	4.016 (102.01)	±0.008 (0.20)	0.030 (0.76)	3.992 (101.40)	±0.008 (0.20)	0.030 (0.76)	2.125 (53.98)	3.280 (83.31)	0.318 (8.08)	0.400 (10.16)	0.09 (2.3)	0.13 (3.3)				
4	4.518 (114.76)	±0.009 (0.23)	0.030 (0.76)	4.491 (114.07)	±0.009 (0.23)	0.030 (0.76)	2.250 (57.15)	3.737 (94.92)	0.337 (8.56)	0.420 (10.67)	0.09 (2.3)	0.13 (3.3)				
5	5.583 (141.81)	±0.010 (0.25)	0.060 (1.52)	5.553 (141.05)	±0.010 (0.25)	0.060 (1.52)	2.625 (66.68)	4.703 (119.46)	0.375 (9.53)	0.470 (11.94)	0.09 (2.3)	0.13 (3.3)				
6	6.647 (168.83)	±0.011 (0.28)	0.060 (1.52)	6.614 (168.00)	±0.011 (0.28)	0.060 (1.52)	3.000 (76.20)	5.646 (143.41)	0.432 (10.97)	0.540 (13.72)	0.13 (3.3)	0.19 (4.8)				
8	8.655 (219.84)	±0.015 (0.38)	0.090 (2.29)	8.610	±0.015 (0.38)	0.090 (2.29)	4.000 (101.60)	7.610 (193.29)	0.500 (12.70)	0.625 (15.88)	0.13 (3.3)	0.19 (4.8)				

^AThe sketches and designs of fittings are illustrative only.
^B Measure from socket entrance face to pipe stop face.
^CSee 6.1.5.